

Work Order ID 82703

Thursday, April 05, 2012 8:57:11 AM

Rush
82703

Page 1

Item ID: D4011-1

Accept

Now!
N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp, Short

Start Date: 4/5/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/5/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: *muf*Date: *12-04-05*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4011

B

100

0.00

100

Waterjet

PURCHASING

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: *B*Prog Rev: *B*

2-Deburr if necessary

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

*AWH/Jm 120405 (12)**muf/Jm 120405 (12)*

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82703

Page 2

Item ID: D4011-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Clamp, Short

Stop ***NS2***

Start Date: 4/5/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 4/5/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

JB 12-4-5

120

QC

Memo

0.00

Quality Control

(12)

130

Form as per dwg

0.00

NC BRAKE

130

Brake NC

Memo

0.00

Brake NC

JB 12/04/09

(12)

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Sczluog

(12)

ME
12-04-09

Picklist Print

Thursday, April 05, 2012 8:57:10 AM

Page 1

Work Order ID: 82703

Parent Item: D4011-1

Parent Item Name: Clamp, Short

Start Date: 4/5/2012

Required Date: 4/5/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC
HOUSE DD verified by:EC

IPP Rev:B 11.05.19 MADE IN

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA 304SS sheet .080		Purchased	No			100	sf	100.0400	0.063	0.7957895			

Location

Loc Qty

Loc Code

MAT020

100.04

117933

6.6

119276

93.44

119276 w/ Jm 120405

12

8 7 6 5 4 3 2 1

D

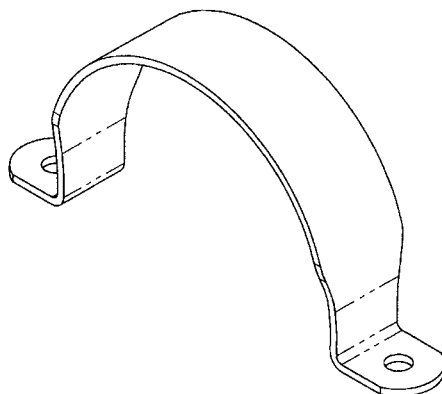
D

C

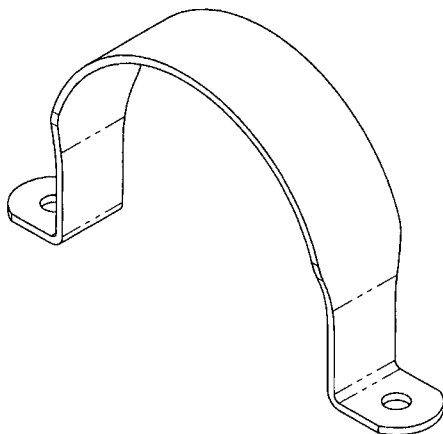
C

B

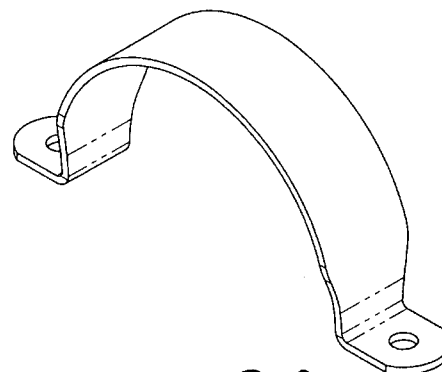
B



D4011-1 CLAMP, SHORT



D4011-3 CLAMP, LONG



D4011-5 CLAMP, SHORT (OEM)

RELEASED
2009-11-24
MD

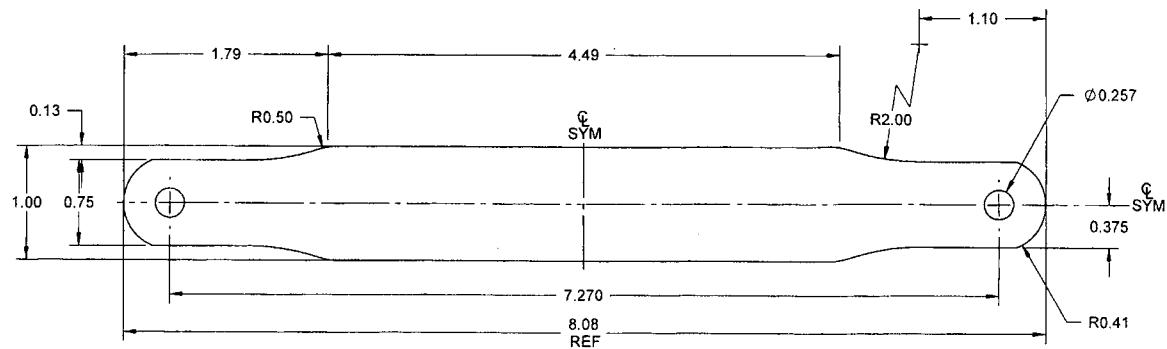
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 14 GAUGE (0.078 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S14GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4011-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs EACH

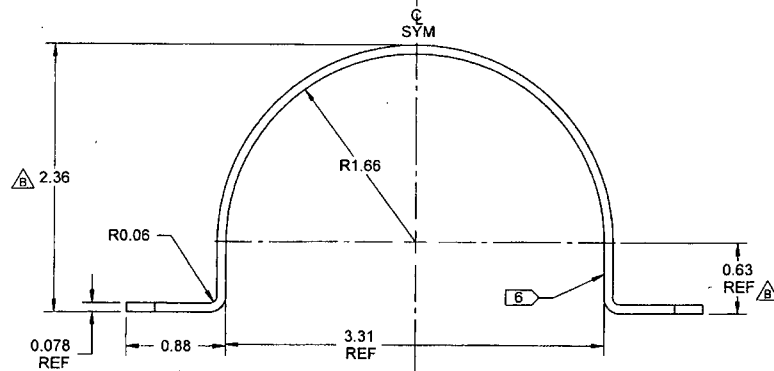
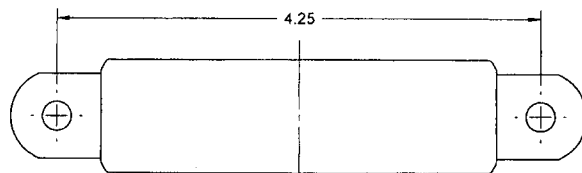
B	SHORTEN HEIGHT OF -143 CLAMPS BY 0.125; ADDED -5. REASON: PROVIDE MORE CLEARANCE UPON INSTALLATION ON OEM SKIDTUBES	MB	09.11.11
A	NEWISSUE	MB	09.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4011 TITLE CLAMP SHEET 1 OF 4 SCALE NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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CHECKED	MB		
MFG. APPR.	MB		
APPROVED	MB		
DE APPR.	MB		
DATE	09.11.11		

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D4011-1F CLAMP, SHORT FLAT PATTERN



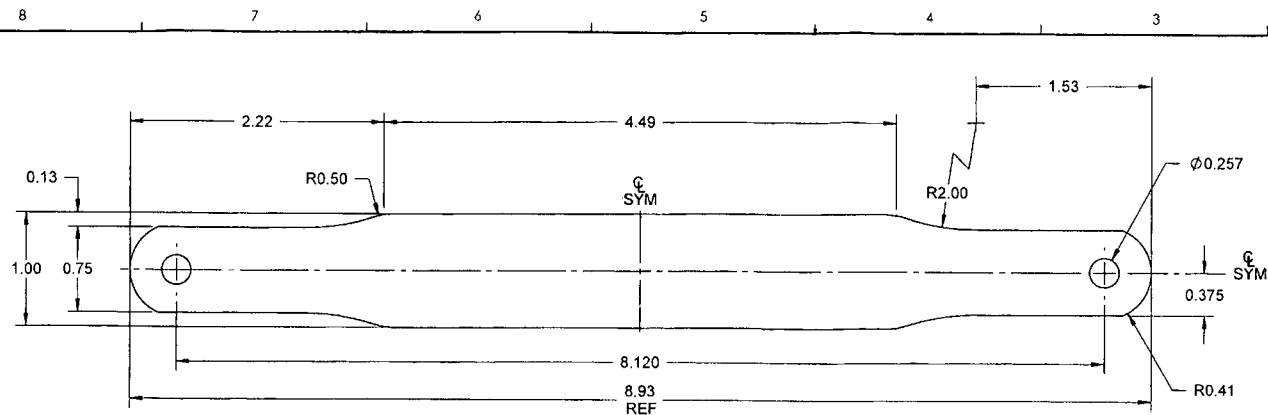
**D4011-1 CLAMP, SHORT
(MAKE FROM D4011-1F)**

42703

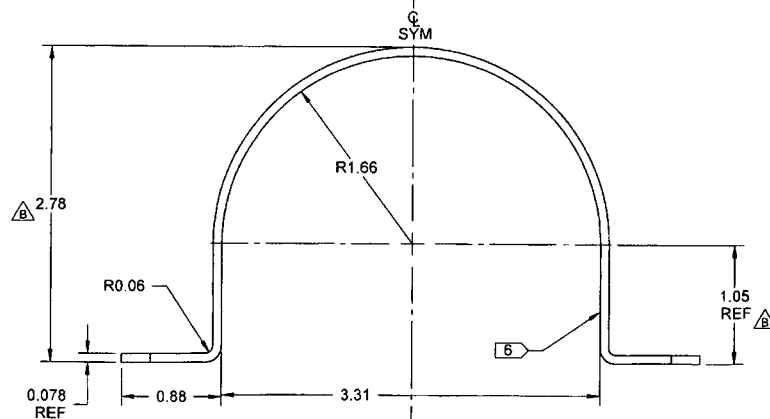
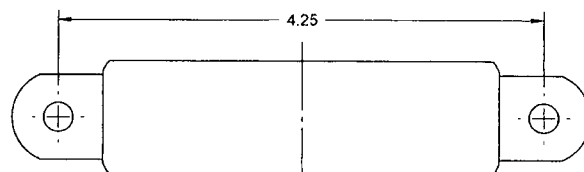
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8 7 6 5 4 3 2 1



D4011-3F CLAMP FLAT PATTERN, LONG

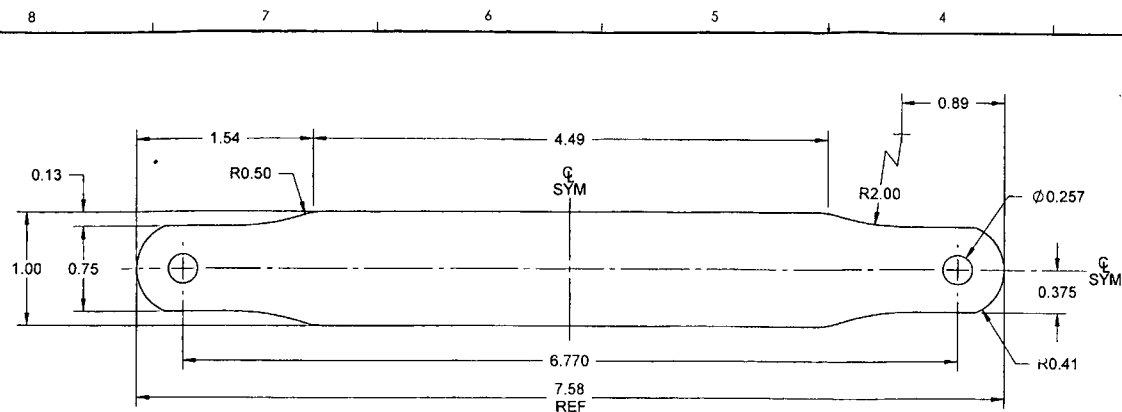


D4011-3 CLAMP, LONG
(MAKE FROM D4011-3F)

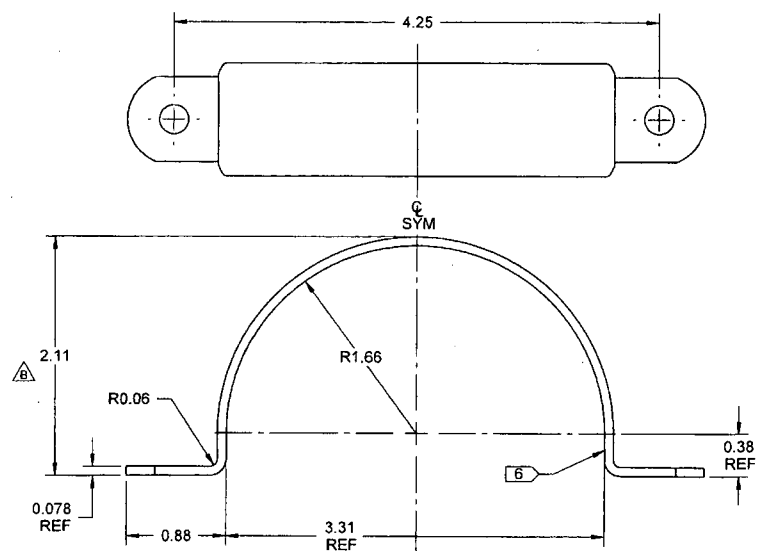
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2009-11-24
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D4011-5F CLAMP, SHORT (OEM) FLAT PATTERN



D4011-5 CLAMP, SHORT (OEM)
(MAKE FROM D4011-5F)

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2009-11-24

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DE APPR.	1	CLAMP	NTS
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